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D3825-043
Job Sheet 196643



Part No: D3825-043

Job Qty: 4 pcs

Part Name: Rib Assembly (Basket End, Lid)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/18/19

Job Tracking No:

Due Date: 7/19/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP REV:A 12.07.24 AS PER REV.B DD VERF:EC IPP REV:B 12.08.08 AS PER DWG REV.C DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	4 pcs	7/19/19	7/19/19	0.00	2.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
130	QC 9	4 pcs	7/19/19	7/19/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
140	QC 5	4 pcs	7/19/19	7/19/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

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			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
150 Packaging 3-1 - Stock - B4B 4 pcs	7/19/19	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	DAS
			Packaging 3 - 20 - B4B	43
			Packaging 3 - 21 - B4B	9-89
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
160 QC 21 - SA 4 pcs	7/19/19	0.00 0.00	QC 21 - SA - 21	
			QC 21 - SA - 70	JUN 27 2019
			QC 21 - SA - 53	DAS

Part Op 100 - Fabricate per Drwg 1- cut D3825-3 rib as per dwg D3825 2- drill hole (3/16") in D3825-3 using DT9822 jig and open
 Descriptions: to finish size as per dwg D3825 6- weld D2327-1 spacer & D4021-9 bushing as per dwg D3825

130 - QC9- Inspect visual per QSI004- Fusion Welds

140 - QC5- Inspect part completeness to step on W/O

150 - Identify as per dwg & Stock Location: LOCATION WA004-7

160 - QC21- Final Inspection - Work Order Release --1- assemble D2325 support gusset together 2- locate D2325 on rib and weld as per dwg D3826 A/R ER316 S.S. Rod Batch: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2327-1	Spacer Bushing	4 pcs (1 ea)	100-Large Fab - Basket - 1	5104170
D4021-9	Bushing	8 pcs (2 ea)	100-Large Fab - Basket - 1	5184054
M304TS0.750W.065	304 Sq Tube .75X.75X.065W	8.5000 ft (2.125 ea)	100-Large Fab - Basket - 1	5177780

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2327-1	4	11	0
	D4021-9	8	42	0
	M304TS0.750W.065	9	1,076	0
Part Specifications				
Specifications could not be found.				

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Container No: S193241



Part: D3825-043

Job No: 196643

Serial No/ Batch: S193241

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/24/19

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :	MRB (QSI042)		
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread				
Other/Details:					